Date:

Wednesday, 6/6/2007 1:53:23 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 32788

Estimate Number

: 12716

P.O. Number

: YIA

This Issue : 6/6/2007 Prsht Rev.

: 31996

S.O. No. : 1/1 12

: SMALL /MED FAB

Part Number **Drawing Number**

Drawing Name

: D353635 D3536 REV A

: 6/19/2007

: GASKET

: N/A Project Number

Drawing Revision AK:

Material Due Date

Qty:

20 Um:

Each

Written By

First Issue

Previous Run

Checked & Approved By

Comment

: Est Rev:A

New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

MNEO60S063

NEOPRENE SHEET 0.063

05/06/14

Comment: Qty.:

0.6507 sf(s)/Unit

Total:

13.0137 sf(s)

NEOPRENE SHEET 0.063

Batch:

FLOW WATER JET

2.0

WATER JE

Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev:

Prog Rev:__

2-Deburr if necessary

3.0



PARTS AS THEY COME OFF MACHINE

4.0

Comment: INSPEC QC8

SECOND CHECK

20

Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:__



Page 1

Form: rorocess

Dari Aerospace Lic	erospace Ltd
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W/O:			1		V	VORK ORDER CI	HANGES			-		
DATE	STEP		i	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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			•						30			
		1.:		<u> </u>			· · · · · · · · · · · · · · · · · · ·					
Part No	:		PAR #:		_ Fault Ca	tegory:	NO	R: Yes	NO DQA	Z	<u></u>	77/86/19
				ř				QA: N/	C Closed	:	_ Date: _	
NCR:				W	ORK OR	DER NON-CONF	ORMANC	E (NCR)				
DATE	CTED	Desc	cription of NC			Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP		Section A		Initial Chief Eng	Action Descri Chief Eng		Sign & Date	Sectio	n C	Chief Eng	QC Inspector
41130150	2.0	Spart Schwas not	rap because feeding Sand	hedaux		Scrap, destroy, re- - Stop machine	place	5AD 57/06/14)		
		PAL +5 Au	rap because feeding Sand in the hose. e very ug	ely.	asion	-Step machive	fix problem		Pose	6.18	asion	0706.18
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NOTE: Date & initial all entries

Date:

Wednesday, 6/6/2007 1:53:24 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32788

Part Number: D353635

Job Number:



Seq. #:

Machine Or Operation:

Description:

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd **WORK ORDER CHANGES** W/O: Approval **Approval STEP** PROCEDURE CHANGE DATE Bv Qtv Chief Eng / Prod Mgr Date QC Inspector Part No: PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Description of NC Verification Approval QC Inspector **Approval** DATE **STEP** Sign & Initial **Action Description** Section A Chief Eng Section C Chief Eng Date Chief Eng

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32788
Description: Gasket	Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

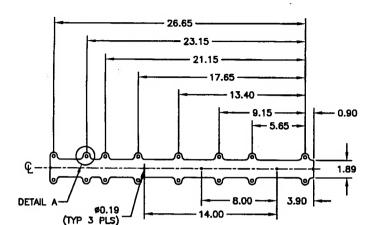
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.150	/		VM-T	
19.75	+/-0.030	19.75	/		M-T	
17.75	+/-0.030	17,75			M-T	
14.25	+/-0.030	14.25			M-T	
9.50	+/-0.030	9,50	/		m-T	
4.75	+/-0.030	4.75	_	-	M-1	
2.00	+/-0.030	2,00			M-T	
6.00	+/-0.030	6.00	/		01-T	
6.75	+/-0.030	6,75			M-7	
0.30	+/-0.030	6,75 0,308			Vern	
0.30	+/-0.030	0.308	/		Seln	
1.89	+/-0.030	1,88			Vern	
Ø0.19	+0.005/-0.001	0.20	/		Vern	
0.063	+/-0.010	0.059	~		Vern	
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Measured by:	SM	Audited by:	Sin	Prototype Approval:	N/A
Date:	07/06/H	Date:	07/06/18	Date:	N/A

Rev	Date	Change	Revised by	Approyed
Α	07.03.14	New Issue	KJ/JLM	all
			771	7/

8 21.12



D3536-11 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT SHOP COPY WITHOUT NOTICE ENGINEERING RETURN TO

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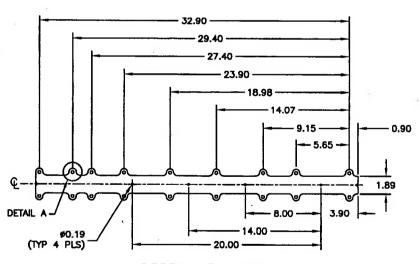
PURPOSE

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COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

DESIGN B	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED //	DRAWING NO. REV. A
#	*	D3536 SHEET 1 OF 6
DATE		TITLE
06.10.25		GASKET 1:10
A	06.10.25	NEW ISSUE

M

06.10.25

GASKET

07.02.12

CHECKED

D3536

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2 약 SCALE 1:10

DRAWING NO.

DART

AEROSPACE PORT HADLOCK,

NO.

B

39.15 35.65 33.65 30,15 24.90 - 19.65 14.40 0.90 5.65 1.89 Ø0.19 (TYP 4 PLS) 8.00 3.90 DETAIL A

D3536-15 GASKET

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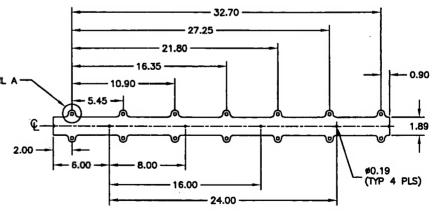
PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

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 Thish. No
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



DETAIL A	21.80 — 16.35 — 10.90 — 5.45 —	- 32.70		0.90 1.89 \$0.19 (TYP 4 PLS)
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DATE 06.10.25 CHECKED B 3 GASKET

D3536 DRAWING NO

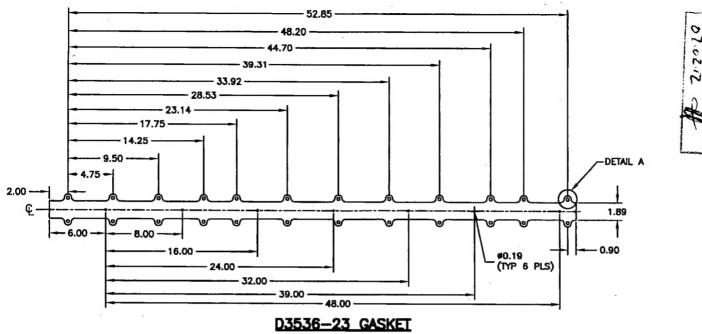
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USA,

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PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT €
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

D3536-31 GASKET

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DETAIL A

#0.19 (TYP 3 PLS)

- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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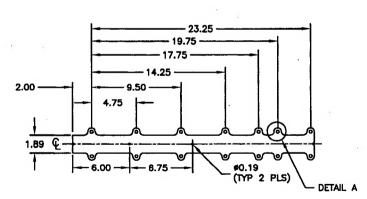
PAGE 6 FOR DETAILS AND SECTION

SUBJECT TO AMENDMENT

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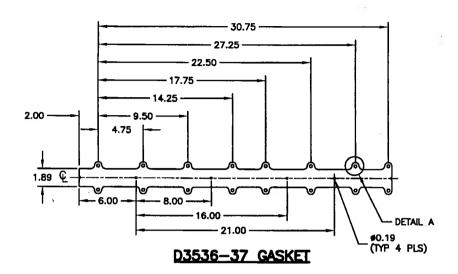
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07.02.12



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PURPOSE

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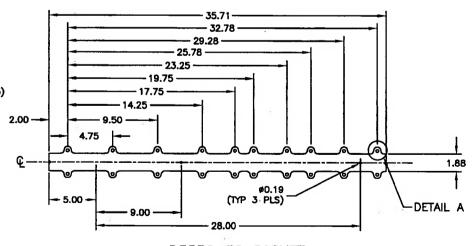
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2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT €
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D3536-39 GASKET



D3536-41 GASKET

#0.19 (TYP 2 PLS)

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DETAIL

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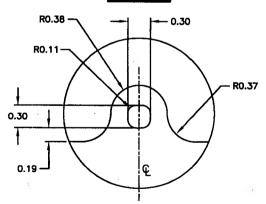
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 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
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7	#	D3536	SHEET 6 OF 6
DATE		TIME 3.1	SCALE
06.10.25		GASKET	1:10